

Work Order ID 50738

July 21, 2009 12:43:31 PM

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Item ID: D2017-125

Accept

Revision ID: E

Item Name: Step Strut

Start Date: 7/06/09 Start Qty: 2.00

Required Date: 7/06/09 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2017

Rev F

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

110

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:15am OVEN TEMPERATURE:

11:45am FINISH TIME:

400°

120

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

P/D

K2

P

K2

Ø

5

⇒ 09/09/10

⇒ 09/09/14

1112260

BR 09-09-14

W/O: 50738		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.09.09	90	Punch tube as per Dwg. + Deburr	SB M. J. O'Connell	09/09/09 04/09/10	2		IE

Part No: D2017-125 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2017-125

Accept



Setup Start



Revision ID: E

Stop



Item Name: Step Strut

Start Date: 7/06/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/06/09 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 258

0.00



Packaging

Memo

0.00

Packaging

9/9/14

(2x) 50

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/15

09-9-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Status	Item ID	Rev	Name	Start Date	Quantity	PeJO	Map Date	Secrap	ap	Qua	mmeind	NEC	ICX	ISortme	Offselan	Ty1	Per	Och	to	lore	Ce	Last	dd	Da
✓	M304TR0.750W.049		304 RD Tube .750...	6/24/09	1.6500	f		100	5	0.0...					1	0	M...					6/3...	6/...	

Picklist Print

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Work Order ID: 50738

Parent Item: D2017-125RevE

Parent Item Name: Step Strut

Comments:

Start Date: 7/06/09

Required Date: 7/06/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No				f	350.2300	3.3000			



304 RD Tube .750 x .049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

350.2300026

107518

7.27

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

111619

13.2700026

112187

300

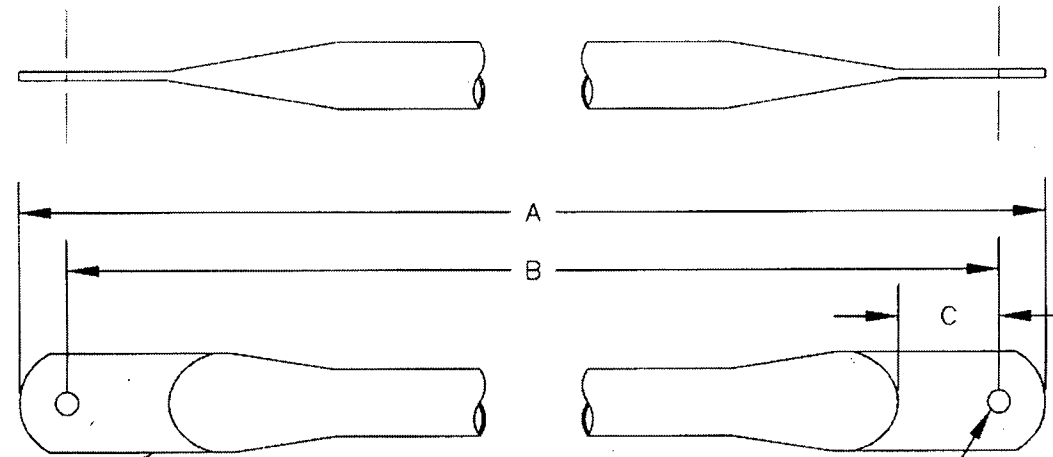
3.300

SB 09/09/09

WFO 50739



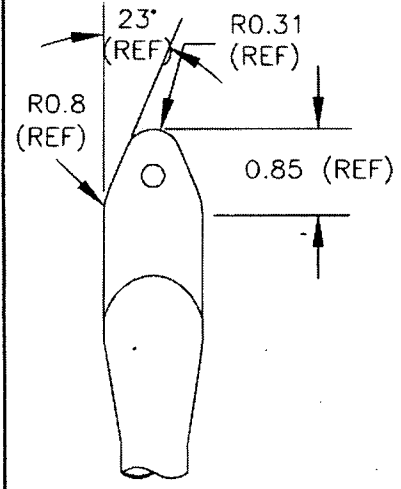
RELEASED



PUNCH ENDS PER
SPEC CTRL D2638
(-119 SEE NOTE)

"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)

DETAIL F
-119 ENDS



Part Number	A	B	C	D	E
D2017-101	17.73	16.93	1.30	0.250	0.312
D2017-103	18.74	17.94	1.30	0.250	0.312
D2017-105	14.95	14.15	1.30	0.250	-
D2017-107	15.61	14.81	1.30	0.250	-
D2017-109	13.93	13.13	1.30	0.250	-
D2017-111	15.30	14.50	1.30	0.250	-
D2017-113	20.50	19.70	1.30	0.250	0.312
D2017-115	12.42	11.62	1.30	0.250	-
D2017-117	13.86	13.06	1.30	0.250	-
D2017-119	26.75	25.95	1.30	0.250	-
D2017-121	12.30	11.50	1.30	0.250	-
D2017-123	12.92	12.12	1.30	0.250	-
D2017-125	19.55	18.75	1.30	0.250	-
D2017-127	20.30	19.50	1.30	0.250	-
D2017-129	31.43	30.63	1.30	0.250	-
D2017-131	19.68	18.88	1.30	0.250	-
D2017-133	30.66	29.86	1.13	0.250	-

NOTE:

FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)
BEND FLARED ENDS 8° UP/ 8° DOWN
MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

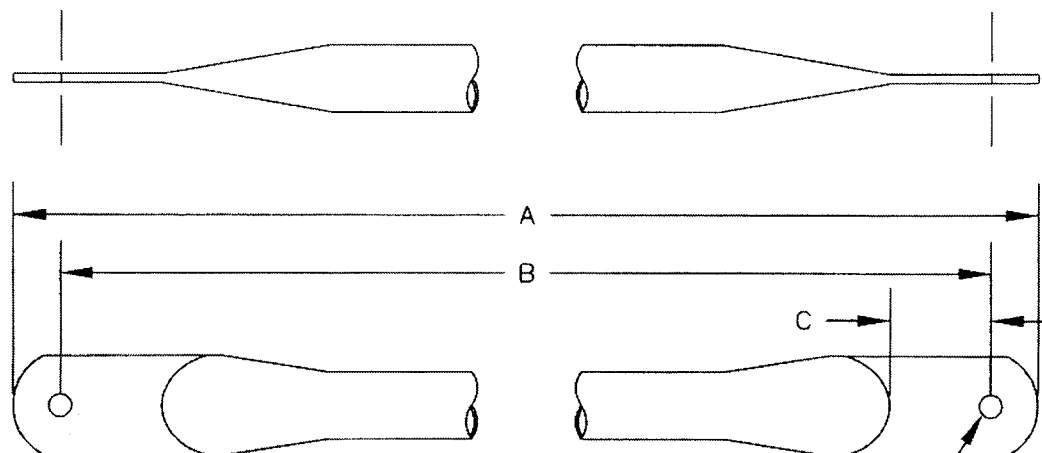
DESIGN	DATE	CHECKED	APPROVED	DRAWING NO.	REV. E
BW	99.04.16	HE	HE	D2017	SHEET 1 OF 2
C	95.01.26			STEP STRUTS	SCALE
D	96.03.28			ADD PARTS	NTS
E	99.04.16			ENDS PUNCHED PER SPEC CTRL: -119 CHANGE (TSR A897)	

DART



DESIGN	BW	DRAWN BY	1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	
DATE	99.04.16	DRAWING NO.	D2017	REV. E
TITLE			SHEET 2 OF 2	
STEP STRUTS			SCALE	
			N/S	

RELEASED
DART QSI 011 KE



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

50738

NOTE:

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POLISHED (WAT NOTE (4332) PER DART QSI 018 4/3/01)